Work Order ID 50384

July 13, 2009 12:36:18 PM

Item ID: D3140-91 **Accept** **Setup Start**

Revision ID: F **Stop**

Item Name: Doubler

Start Date: 7/15/09 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 7/15/09 **Req'd Qty:** 4.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** MF **Date:** 09-07-15 **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3140	**Revision Nbr** Rev F					4			
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				FB 9-8-17			
FLOW CNC Waterjet	1-Cut as per Dwg D3140 **ENSURE THAT GRAIN DIRECTION IS CORRECT*** ☐Dwg Rev: F ☐Prog Rev: F ☐2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				FB 9-8-17			(4)
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control									

=> 8/01/08/13

Work Order ID 50384

July 13, 2009 12:36:18 PM

Item ID: D3140-91 **Accept** **Setup Start** **Stop**

Revision ID: F

Item Name: Doubler

Start Date: 7/15/09 **Start Qty:** 4.00 **Cust Item ID:**

Required Date: 7/15/09 **Req'd Qty:** 4.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00				4	0		
Small Fab	**Memo**	0.00							
Small Fab	1-Form as per Dwg D3140 ☐2-Scuff surfaces with 80grit sandpaper per QSI 006☐3-Deburr.☐ No sharp edges	SB 09/09/11							
140	QC5- Inspect part completeness to step on W/O	0.00 ⇒ SB 09/09/11				~~4~~	0		
QC	**Memo**	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00 AL 09/09/15				X 4	0		
HandFinish	**Memo**	0.00							
Hand Finishing									

Work Order ID 50384

July 13, 2009 12:36:18 PM

Item ID: D3140-91
Revision ID: F
Item Name: Doubler

Start Date: 7/15/09 **Start Qty:** 4.00
Required Date: 7/15/09 **Req'd Qty:** 4.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC3- Inspect Part Finish	0.00				(4)	0		
	Memo	0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location:_____	0.00							
	Memo	0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

=> 8/21/15

9/9/15 4x EP

09/09/16

4 09.09.16

Picklist Print

July 13, 2009 12:36:17 PM

Work Order ID: 50384

Parent Item: D3140-91RevF

Parent Item Name: Doubler

Comments:

Start Date: 7/15/09 **Required Date:** 7/15/09

Start Qty: 4.00 **Required Qty:** 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	111.0100	0.6211			

2024-T3 .032 sheet

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
MAT	111.01		
102942	1.5		
105555	5		
106272	8.47		
108595	3		
109240	7.02		
110778	34.02		
111699	49		111699 KB 9-8-12
18147	3		

(4)

DART AEROSPACE LTD	Work Order:	50384
Description: Doubler	Part Number:	D 3140-91
Inspection Dwg: D 3140 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.140	+/- .030	.408	X			
.75	+/- .030	.754	X			
4.06	+/- .030	4.062	X			
5.00	+/- .030	4.999	X			
.037	+/- .010	.037	X			

Measured by:	KB
Date:	9-8-17

Audited by:	J
Date:	05/06/13

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3140 — REV. F — SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR — SCALE NTS

A	02.04.18	NEW ISSUE
B	03.01.23	REMOVE −65/−81/−83; ADD −301/−303
C	04.11.08	CHANGE DELASTEK SPEC. TEC−77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE −95/−97/−98 TO 106°
D	05.11.23	ADD −103/−104/−105/−106; REMOVE −67
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON −08/−07, 1.00 WAS 1.20 ON −09/−10
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140−09/−92/−104 SHOWN D3140−10/−91/−103 OPPOSITE

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MF 09-07-15

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

D

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1. COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2. FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3. MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

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4. MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5. MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6. MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7. MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8. ALL DIMENSIONS IN INCHES

9. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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10. MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

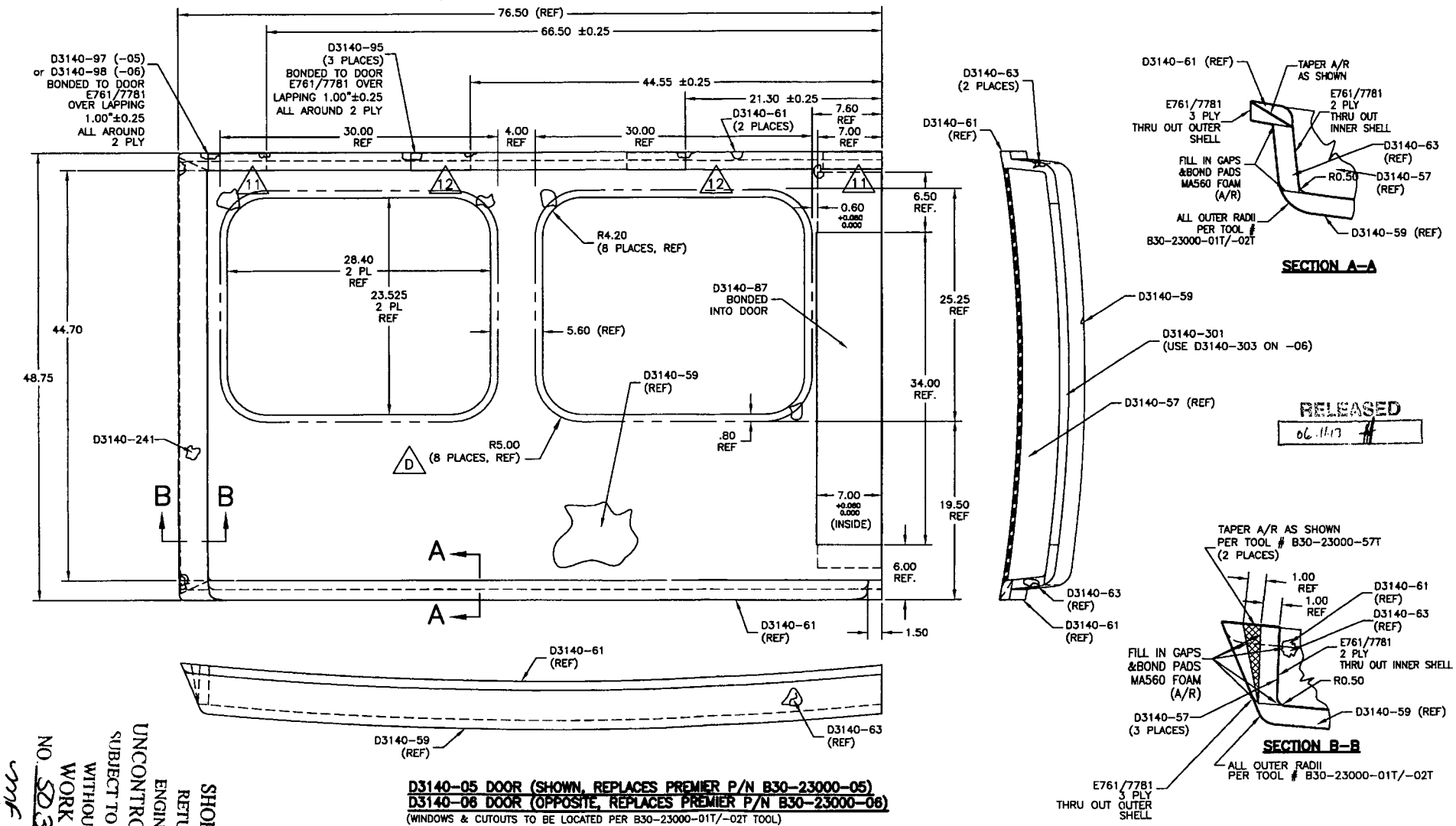
11. DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12. DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13. RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14. PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND ALODINE PER DART QSI 005 4.1

F



D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)

(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

1 2 3

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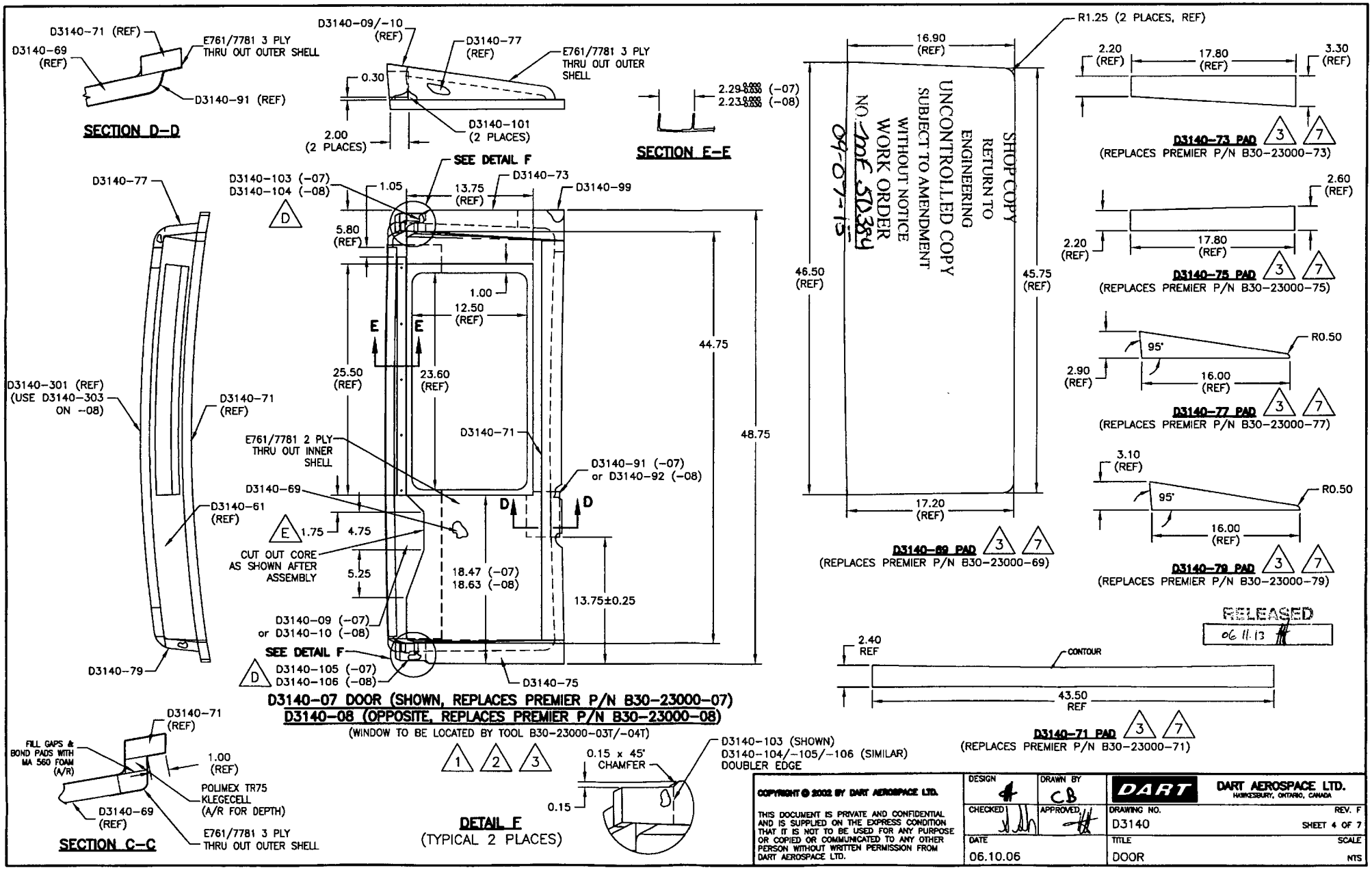
DATE 06.10.06		SHEET 3 OF 7
		TITLE DOOR SCALE NTS



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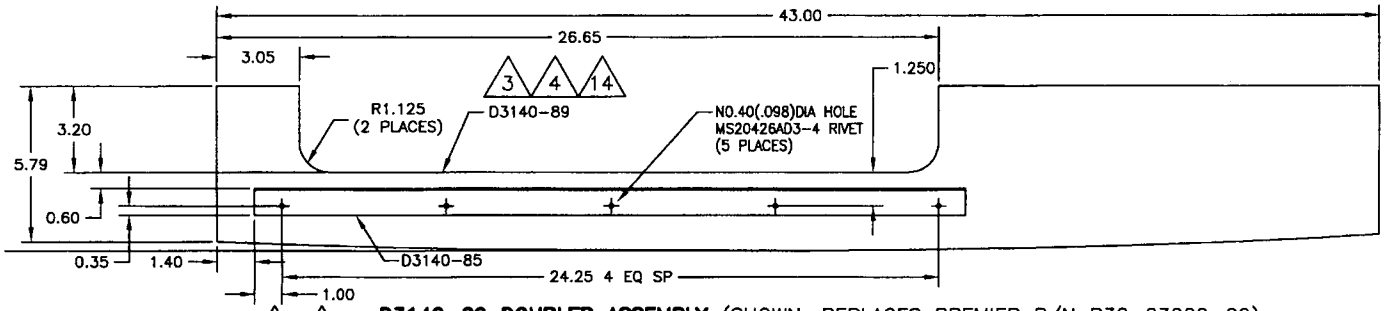
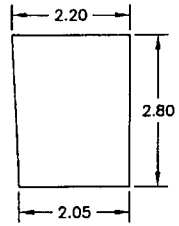
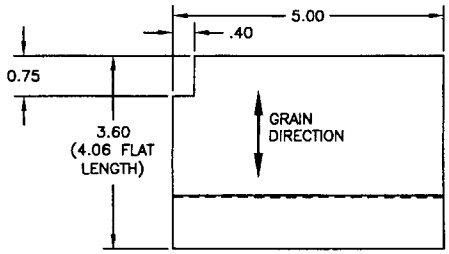
		SHEET 4 OF 7
DATE 06.10.06		TITLE DOOR SCALE NTS



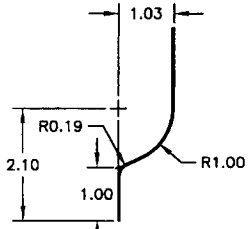
D3140-09 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-09)
D3140-10 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)



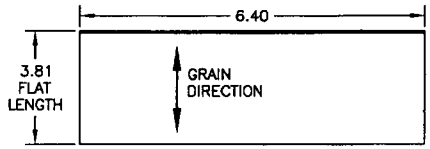
D3140-101 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-101)

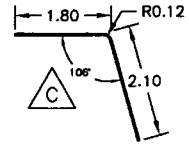


D3140-91F FLAT PATTERN
(USE TO MAKE D3140-91/-92 DOUBLERS)



D3140-92 DOUBLER 4 14 F
(SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-91)





D3140-95 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-95)

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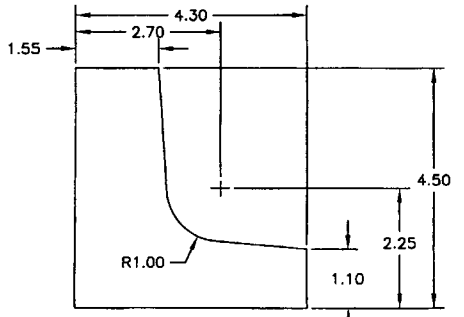
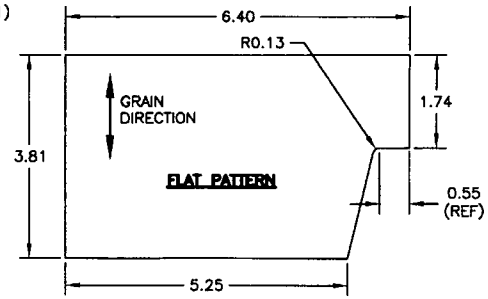
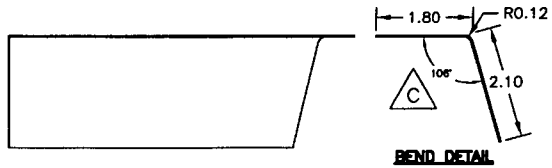


D3140-99 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
(USE TO MAKE D3140-97/-98 DOUBLERS)



BEND DETAIL

D3140-97 DOUBLER 4 14
(SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
(OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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		SHEET 5 OF 7
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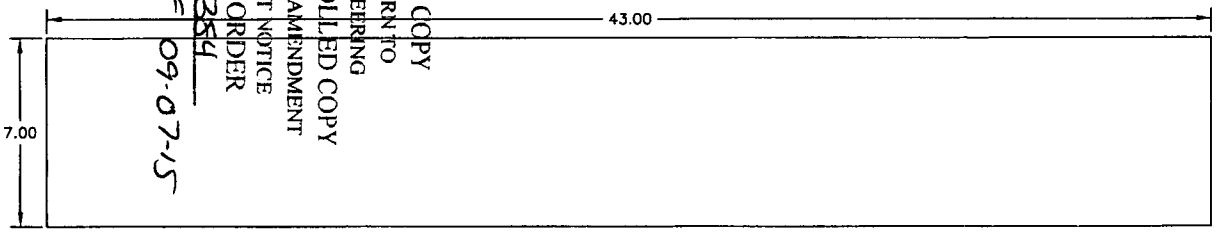
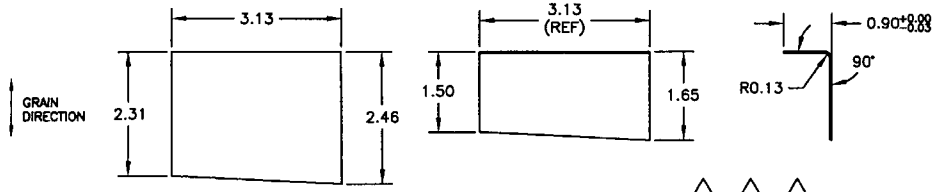


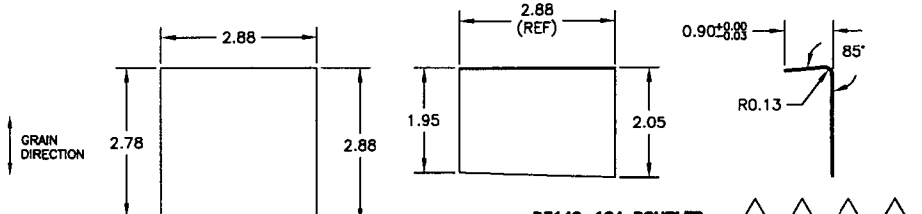
D3140-87 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-87)



D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER
D3140-106 OPPOSITE

4 14 D

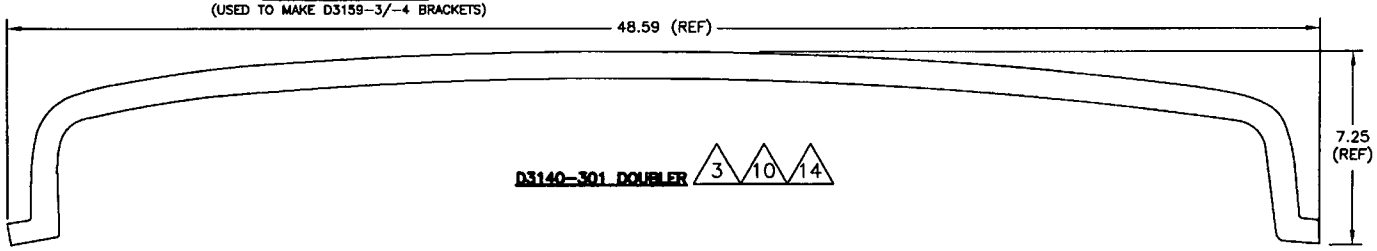


D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

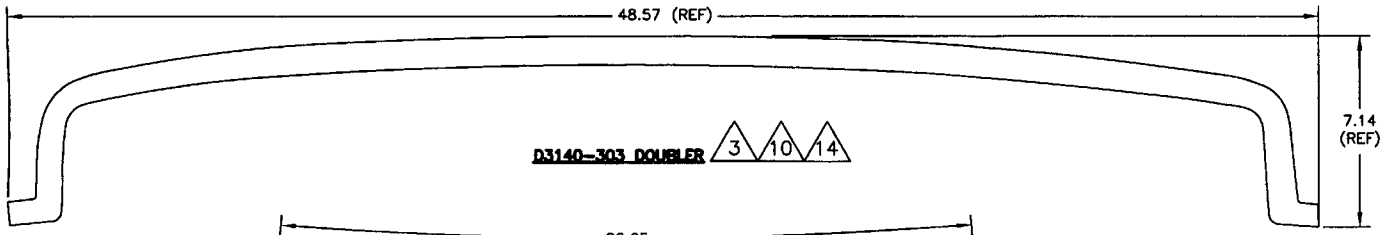
D3140-104 DOUBLER
D3140-103 OPPOSITE

4 14 D F

D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER 3 10 14



D3140-303 DOUBLER 3 10 14

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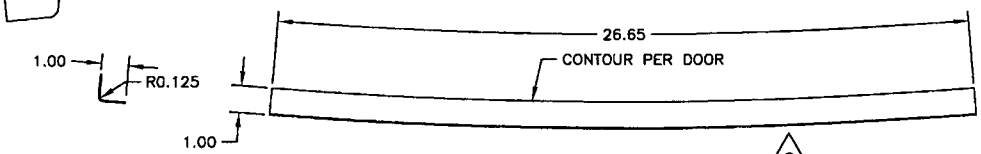

D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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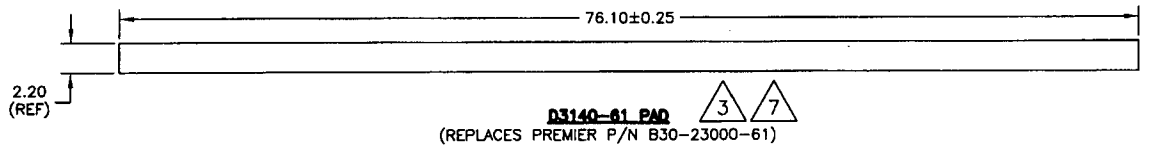
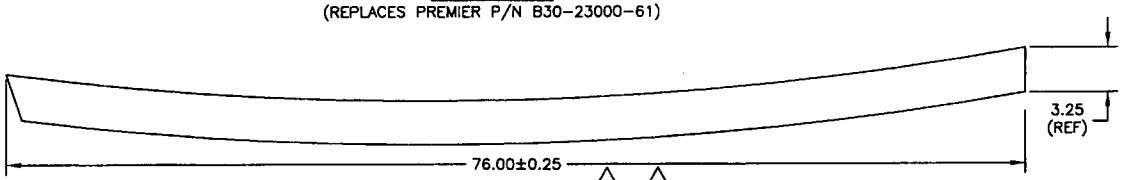
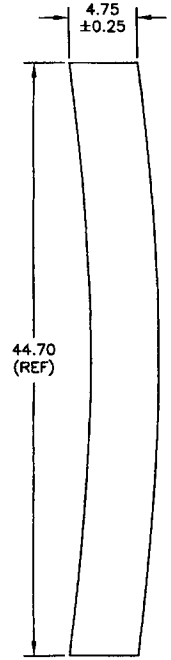
		SHEET 6 OF 7
DATE 06.10.06		TITLE DOOR — SCALE NTS



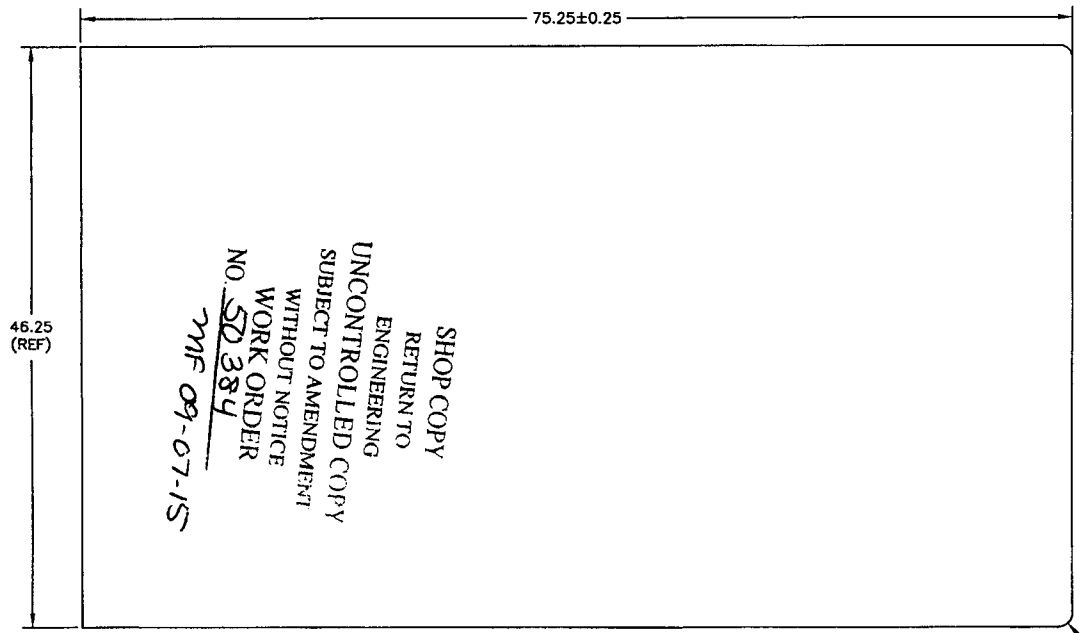
D3140-61 PAD 3 7
(REPLACES PREMIER P/N B30-23000-61)



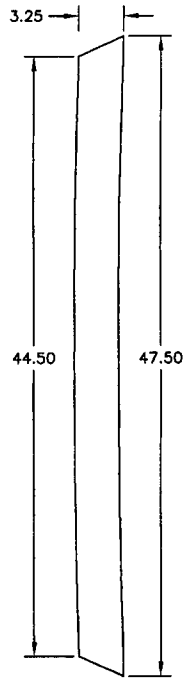
D3140-63 PAD 3 7
(REPLACES PREMIER P/N B30-23000-63)



D3140-57 PAD
(REPLACES PREMIER
P/N B30-23000-57)
3 7



D3140-59 PAD 7
(REPLACES PREMIER P/N B30-23000-59)



D3140-241 DOUBLER 5 14
(REPLACES PREMIER P/N B30-23000-241)

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DESIGN	DRAWN BY CB	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3140	REV. F
DATE 06.10.06		SHEET 7 OF 7	
TITLE DOOR		SCALE NTS	